

Work Order ID 88524

88524

Page 1

August-02-12 11:49:27 AM

Item ID: D3204-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Release Pedal Assembly
 Start Date: 7/27/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-08-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3204 | Rev A1 | | | | | | | | |

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.
 2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.
 3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.

[Signature] 12-11-19

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

H *[Signature]* 12-11-20 **DAS 18 2-89**

Work Order ID 88524

88524

Page 2

August-02-12 11:49:27 AM

Item ID: D3204-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Release Pedal Assembly
Start Date: 7/27/12 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 8/24/12 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|---------------------------------------|---|--------------|--|--|--|---|--|--|--|
| 120 *120* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | 4 | | | |
|---------------------------------------|---|--------------|--|--|--|---|--|--|--|

| | | | | | | | | | |
|--|---|--------------|--|--|--|----|--|--|-----------------|
| 130 *130* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 4X | | | m/z 12/11/21 |
|--|---|--------------|--|--|--|----|--|--|-----------------|

| | | | | | | | | | |
|--|---|--------------|--|--|--|----|--|--|-----------------|
| 140 *140* Powdercoat Powder Coating | Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: FINISH TIME: | 0.00 0.00 | | | | 4X | | | m/z 12/11/21 |
|--|---|--------------|--|--|--|----|--|--|-----------------|

m122966

12-03
3200 F
12-30

Work Order ID 88524

88524

Page 3

August-02-12 11:49:27 AM

Item ID: D3204-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Release Pedal Assembly

Start Date: 7/27/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/24/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 160 | | 0.00 | | | | | | | |
| *160* | Small Fab | | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Install D3204-7 bushing as shown in Dwg D3204 | | | | | | | | |
| 170 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

H 12/11/21

4/2/11/23

4 12/11/23

Work Order ID 88524

88524

Page 4

August-02-12 11:49:27 AM

Item ID: D3204-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Release Pedal Assembly
 Start Date: 7/27/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/24/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|------------------------------|
| 180 | Identify as per dwg & Stock Location: <u>CA</u> | 0.00 | | | | 4 | | | <u>12/11/22</u> |
| *180* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 190 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | <u>12/11/23</u> |
| *190* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | <u>ME</u> <u>12-11-23</u> |

Picklist Print

August-02-12 11:49:26 AM

Page 1
[Signature]

Work Order ID: 88524
Parent Item: D3204-041
Parent Item Name: Release Pedal Assembly

Start Date: 7/27/12 Required Date: 8/24/12
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3204-1 Tube | | Manufactured | No | 88332 x4 | | 100 | Each | 0.0000 | 1 | 6 | | EL 12-11-14 | |
| D3204-11 Plate | | Manufactured | No | | | 100 | Each | 12.0000 | 1 | 6 | | EL 12-11-14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | 88362 x4. | WA | 12 | | | | | | | |
| | | | | | 86778 | 12 | | | | | | | |
| D3204-13 Gusset | | Manufactured | No | | | 100 | Each | 14.0000 | 2 | 12 | | EL 12-11-14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | WA | | 14 | | | | | | | |
| | | | | | 85984 | 14 | | | | | | | |
| D3204-3 Arm | | Manufactured | No | | | 100 | Each | 15.0000 | 1 | 6 | | EL 12-11-14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | WA | | 10 | | | | | | | |
| | | | | | 86709 | 10 | | | | | | | |
| | | | | WA019 | | 5 | | | | | | | |
| | | | | | 79804 | 5 | | | | | | | |
| D3204-5 Arm | | Manufactured | No | | | 100 | Each | 14.0000 | 1 | 6 | | EL 12-11-14 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | WA | | 14 | | | | | | | |
| | | | | | 85982 | 4 | | | | | | | |
| | | | | | 86702 | 10 | | | | | | | |

Picklist Print

August-02-12 11:49:27 AM

Page 2

Work Order ID: 88524

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 7/27/12

Required Date: 8/24/12

Start Qty: 6.00

Required Qty: 6.00

D3204-7
Bushing

Manufactured No

160 Each 41.0000

2

12

Location

Loc Qty

Loc Code

GA

41

77091

1

85981

40

D3204-9

Pedal

Manufactured No

100 Each 19.0000

1

6

Location

Loc Qty

Loc Code

WA

19

85980

9

87104

10

[Handwritten signature]

8

12-1-14

4

August-02-12 11:49:27 AM

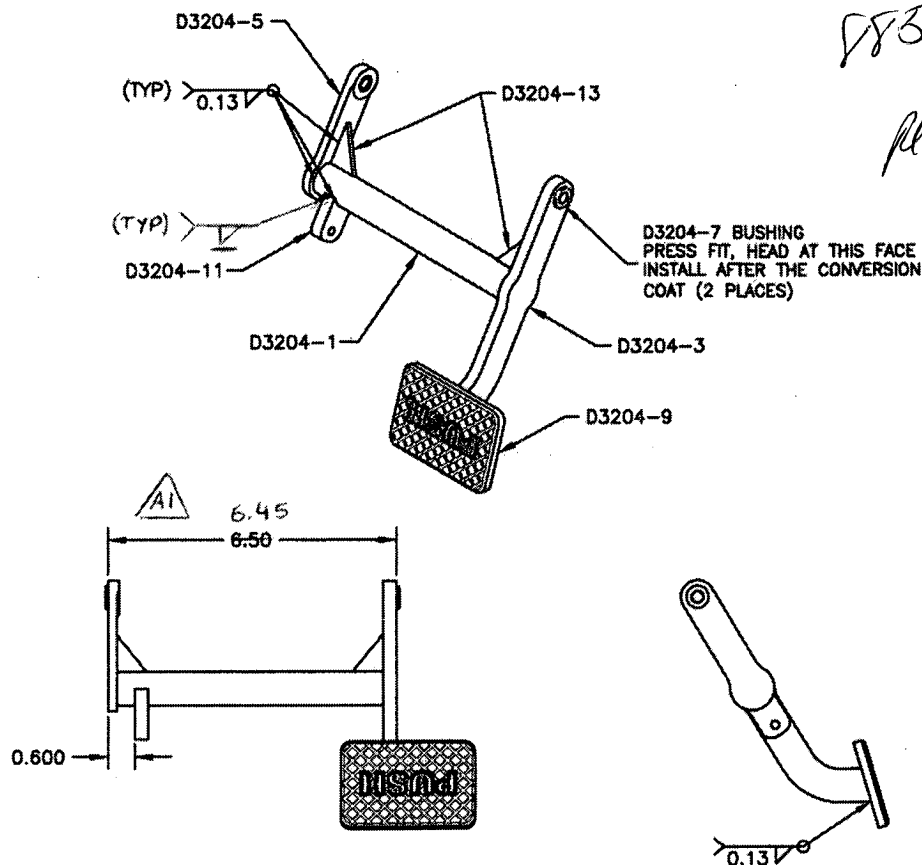
Shop Packet Print

Page 2



| | | | |
|------------------|----------|---|------------------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D3204 | REV. A SHEET 1 OF 3 |
| DATE 04.01.27 | | TITLE RELEASE PEDAL ASSEMBLY | SCALE NTS |
| A | 04.01.27 | NEW ISSUE | |
| A1 | 05.07.15 | 6.45 WAS 6.50 | |

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

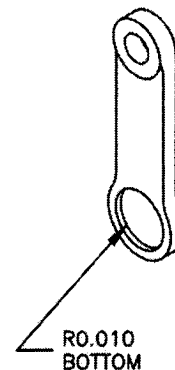
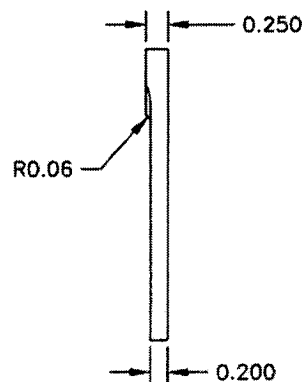
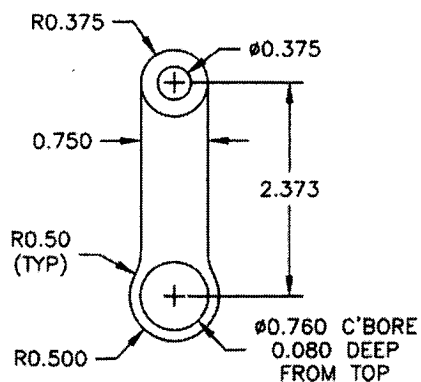
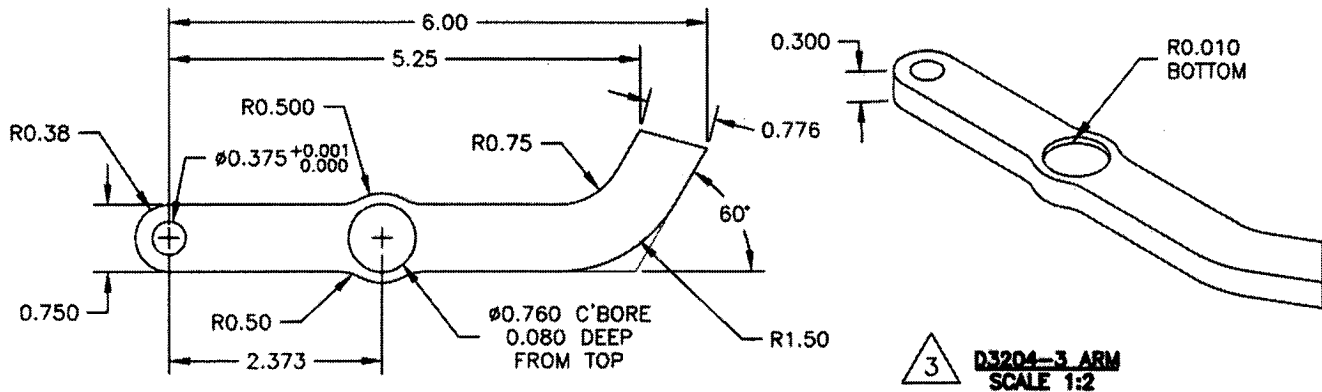
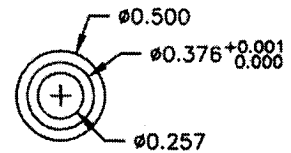
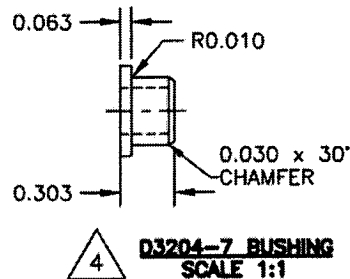
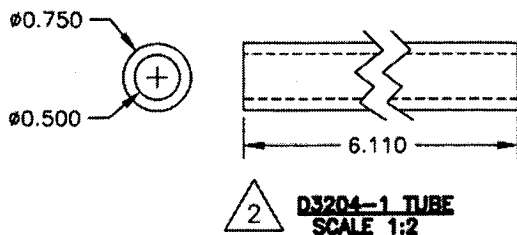
- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN [Signature] | DRAWN BY [Signature] | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3204 | REV. A SHEET 2 OF 3 |
| DATE 04.01.27 | | TITLE RELEASE PEDAL ASSEMBLY | SCALE NTS |

RELEASED
04.04.05 [Signature]

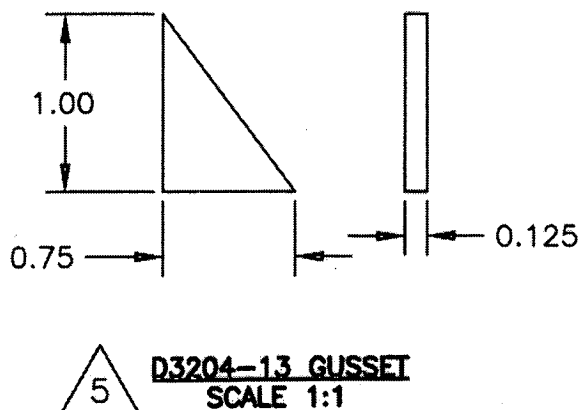
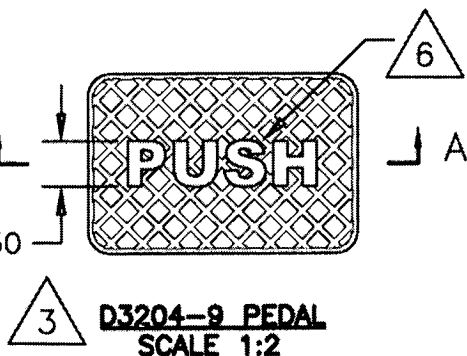
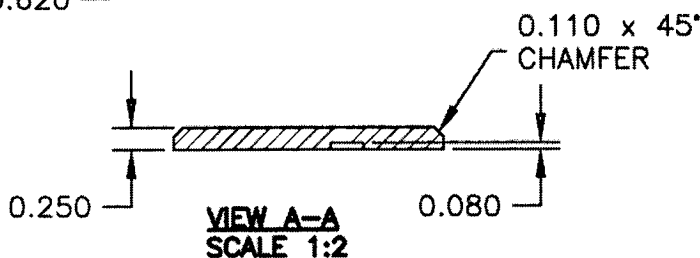
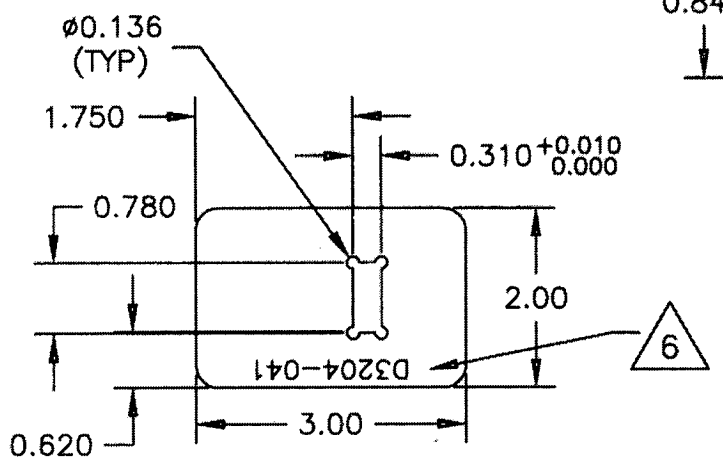
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>RH</i> | DRAWN BY <i>RH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3204 | REV. A SHEET 3 OF 3 |
| DATE 04.01.27 | | TITLE RELEASE PEDAL ASSEMBLY | SCALE NTS |

RELEASED
04.04.30



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.